



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5076-045

Job Sheet 195449



Part No: D5076-045

Job Qty: 4 pcs

Part Name: Fwd Inboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/22/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5076 rev.b IPP REV:A 18.11.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		6/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

NOV 21 2019

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 Small Fab - 2 - B4B	4 pcs	6/20/19	0.39 6.25	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
130 QC 5	4 pcs	6/20/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
140 Powdercoat - 4 Black Sand - B4B	4 pcs	6/20/19	0.00 0.22	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
150 QC 3	4 pcs	6/20/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
160 Small Fab - 3 - B4B	4 pcs	6/20/19	0.00 6.25	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		

NOV 25 2019

NOV 25 2019
DAS
58
9-89

BX 19 11-26

NOV 26 2019
DAS
58
9-89

NOV 26 2019

170 QC 5	4 pcs	6/20/19	0.00 0.00	Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					NOV 26 2019
180 Packaging 3-1 - Stock - B4B	4 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 617
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

Plex 5/22/19 3:16 PM Dart.lajeunesse.marie

DAS
40
9-89

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Pick Kit)

Descriptions: 120 - 1-Assemble as per dwg, do not install grommets and rubber seal. ***Torque screws as per dwg note ***

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Black Sandtex(Ref:4.3.5.7) per QS1005.4.3) *** MASK NUT PLATE HOLES PER DWG *** START TIME:

OVEN TEMPERATURE: 320° FINISH TIME: 9:00 11/30/19

150 - (QC3- Inspect Part Finish)

160 - Install rubber seals and grommets. Cut D4441-1 Rubber Seal to given length. - Cut qty 1 to 4.2" - Cut qty 2 to 2.6" - Cut qty 1 to 6.7" - Cut qty 1 to 6.4" - Cut qty 1 to 9.4" 3M 1300 batch: 5214697 up 9/02/21.

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location:)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5076-1	Bracket	4 pcs (1 ea) ST613	110-Packaging 1 - Pick Kit	8214106
D5076-3	Bracket	4 pcs (1 ea) ST613	110-Packaging 1 - Pick Kit	1x5077423-3x5214986
MS20426AD3-3	Rivet	56 Ea (14 ea) ST312	110-Packaging 1 - Pick Kit	8174201
MS20470AD4-3	Rivet, Universal Head	60 Ea (15 ea) ST310	110-Packaging 1 - Pick Kit	8050689
MS21075L08	Anchor Nut	28 Ea (7 ea) ST294	110-Packaging 1 - Pick Kit	5156774
D5076-5	Bracket	4 pcs (1 ea) ST614	110-Packaging 1 - Pick Kit	5160870
AN525-832R6	Screw	12 Ea (3 ea) ST324	160-Small Fab - 3 - B4B	8133786
D4435-041	Bracket Assembly	4 pcs (1 ea) ST091	160-Small Fab - 3 - B4B	8218000
D4440-1	Grommet	4 pcs (1 ea) GA127P	160-Small Fab - 3 - B4B	8148619
D4441-1	Rubber Seal	10.5840 ft (2.646 ea) ST422	160-Small Fab - 3 - B4B	8092167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D5076-1	4	5	0
	D5076-3	4	5	0
	D5076-5	4	8	0
	MS20426AD3-3	56	7,340	0
	MS20470AD4-3	60	4,206	0
	MS21075L08	28	185	0
160-Small Fab - 3 - B4B	AN525-832R6	12	199	0
	D4435-041	4	7	0
	D4440-1	4	233	0
	D4441-1	11	341	0

Part Specifications
Specifications could not be found.

Plex 5/22/19 3:16 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)																													
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition		Completed By																													
Description Work Order Deviation				Lead hand / Supervisor																																	
				QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																		
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																		
Crushing	BOM/Route	Grain Direction	Drawing																																		
Cracks	Broken/Damage/Defect	Weld	Finish																																		
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																																		
Marks/Chatter	Drill Holes	Out of Sequence	Misread																																		
Mislabeled	Fit/Function	Off-set/Set-up																																			
		Other/Details:																																			